Work Order ID 53453

November 6, 2009 8:19:29 AM

Item ID: D3275-1 **Accept** **Setup** **Start**

Revision ID: A1 **Stop**

Item Name: Crossbolt Spacer

Start Date: 05/11/2009 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 13/11/2009 **Req'd Qty:** 40.00 **Customer:**

Reference:

Approvals: **Process Plan:** Bl **Date:** 09-11-5 **Tooling:** ____ **Date:** ____ **Run** **Start**

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3275	Rev A1

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours		Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Hardinge Hardinge CNC Lathe Small	Hardinge CNC LATHE SMALL **Memo** 1-Turn as per Folio FA469 and Dwg D3275	0.00 0.00	09.11.15				
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00	09.11.15	49			
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	09/11/16	49			

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Item ID: D3275-1 **Accept**

Revision ID: A1

Item Name: Crossbolt Spacer

Setup Start / Stop

Start Date: 05/11/2009 **Start Qty:** 40.00

Required Date: 13/11/2009 **Req'd Qty:** 40.00

Cust Item ID:

Customer:

Reference:

Run Start / Stop

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Identify as per dwg & Stock Location: Bentley **Memo**	0.00 0.00				9/11/10	SP	(490)	
140 QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00							09/11/17

MF
09-11-16

Picklist Print

November 6, 2009 8:19:35 AM

Work Order ID: 53453

Parent Item: D3275-1RevA1

Parent Item Name: Crossbolt Spacer

Start Date: 05/11/2009 **Required Date:** 13/11/2009

Comments:

Start Qty: 40.00 **Required Qty:** 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.3125W.058		Purchased	No			100	f	113.0600	11.2253			

ALUM TUBE .3125 x .058w

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	113.06	
110532	1.71	
111470	8.43	
111874	14.32	
112142	88.6	

09.11.15

DART AEROSPACE LTD	Work Order:	534153
Description: Crossbolt Spacer	Part Number:	D3275-1
Inspection Dwg: D3275 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.180	+/-0.010	3.185	✓			
0.025 – 0.030	N/A	.025	✓			
45°	+/-0.01°	45°	✓			
Ø0.313	+0.010/-0.005	.310	✓			
0.058	Max = 0.0605 Min = 0.0555	.058	✓			

Measured by:	[signature]
Date:	09-11-15

Audited by:	[signature]
Date:	09/11/16

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.19	New Issue	KJ/JLM	
B	06.03.09	Dimension Ø0.197 was Ø0.201	KJ/JLM	
c	09.05.04	Ø0.197 dimension removed	KJ/DD [signature]	[signature]

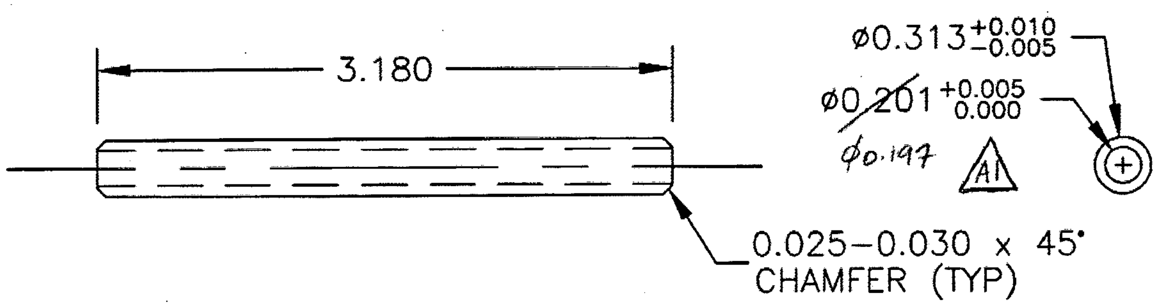
DART

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3275	REV. A SHEET 1 OF 1
DATE 04.03.10		TITLE CROSS BOLT SPACER	SCALE 1:1
A	04.03.10	NEW ISSUE	
A1	04.10.19	CHANGE MAT'L SPEC	

RELEASED 04.06.22

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED C
SUBJECT TO AMEN
WITHOUT NOTI
WORK ORDE
NO. 53453
09-11-5



D3275−1 CROSS BOLT SPACER

1) MATERIAL: 6061−T6 (QQ−A−200/8 OR QQ−A−225/8)
(REF DART SPEC. ~~M6061T6R~~) M6061T6T0.313W.058 A1
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED